

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026750**Date Inspected:** 21-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Pat Swain**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Sections**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager observed the following.

SAS – Tower – F.W. Spencer:

This QA Inspector was informed by F.W. Spencer foreman Hector Garcia that production welding of piping would not be performed this shift.

Orthotropic Bridge Girder (OBG) section:

12E/13E Longitudinal Stiffener (LS) LS-4, LS-5 and LS-6:

This QA Inspector performed Ultrasonic Testing (UT) on LS-4, LS-5 and LS-6. This QA Inspector observed the Longitudinal Stiffeners at this location had an offset as documented in Request For Information (RFI) ABF-RFI-002616R00. This QA Inspector made a sketch of the weld joint including the maximum offset and it appeared the UT could provide coverage as required by the contract. This QA Inspector used the sketch during the UT to aid in locating the various sound paths. This QA Inspector performed UT from both faces and from both sides of the weld joint to obtain the required coverage. This QA Inspector observed from the marking on LS-4 and LS-5 that QC Inspector Pat Swain had performed the UT and confirmed with Lead QC Inspector Bonifacio

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Daquinag Jr. that QC Inspector John Pagliero had performed the UT inspection on LS-6. This QA Inspector observed a UT signal indication while performing the scanning on LS-4. This QA Inspector discussed the signal with QC Inspector Pat Swain. QC Inspector Pat Swain decided to re-inspect the area where the signal was observed by this QA Inspector. QC Inspector Pat Swain stated he observed a signal with a rating that exceeded a Class A defect. This QA Inspector observed QC Inspector Pat Swain determine the location and size (length) of the defect. QC Inspector Pat Swain informed this QA Inspector he thought this would be the third time excavation (R-3) at this area and a Critical Weld Repair (CWR) would need to be submitted and approved by the Engineer prior to starting the excavation. Later in the shift Lead QC Inspector Bonifacio Daquinag Jr. informed this QA Inspector this would be an R-3 and that he would start the paperwork for the submittal. The UT performed on LS-5 and LS-6 by this QA Inspector appeared to comply with the contract requirements; for specific details see Ultrasonic Inspector Report (6027) for this date.

Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) and Caltrans personnel during this shift. Except as described above and noted above there were no notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
